

Date: Wednesday, 24/09/2008 12:48:00 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WASHER
<b>Job Number</b> :	42270		
<b>Estimate Number</b> :	10374		
<b>P.O. Number</b> :		<b>Part Number</b> :	D31375
<b>This Issue</b> :	24/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3137 REV E
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37881	<b>Drawing Revision</b> :	F
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08.9.24</u>	<b>Due Date</b> :	31/10/2008
<b>Comment</b> :	Est A 04.11.04 New issue KJ/JLM		
	Est Rev B 08.07.03 ECN1207 EC verified by DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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**Comment:** Qty.: 0.0218 f(s)/Unit Total : 1.0920 f(s)  
 6061-T6 Round Bar 0.75"  
 Material: 6061-T6 Aluminum Bar Ø.750" (QQ-A-200/8 or QQ-A-225/8)  
 (M6061T6R.7500) Batch: M102478

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
 1-Machine as per Folio FA471 and Dwg D3137  
 2-Identify as D3137-5  
 3-Deburr

SD 08/10/04 (50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SD 08/10/04 (50)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JS 08/10/05 (50)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

M-L 08/10/07 (50X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 24/09/2008 12:48:00 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 42270

Part Number: D31375

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-10-07 (50x)		
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: Inspect work to Step 7 5-8/10/08 (50x) centered		
8.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: 238 8/10/8 sf		
9.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE 08/10/09		

Job Completion



U 88-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

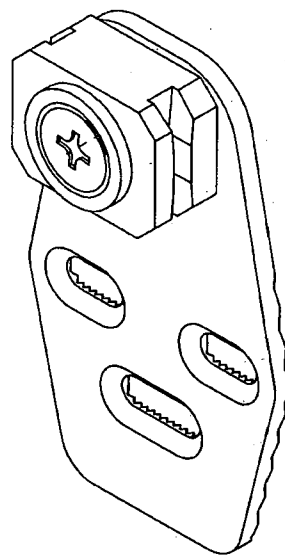
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

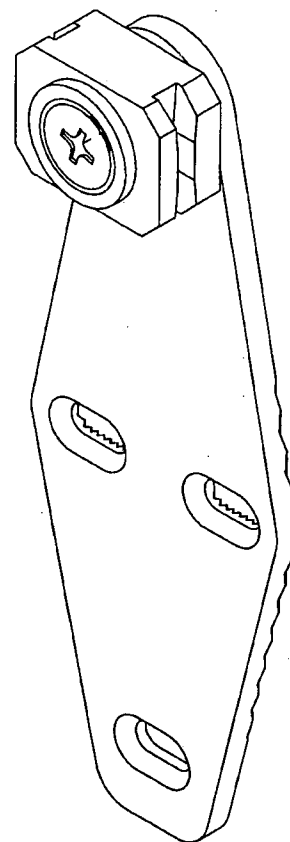
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

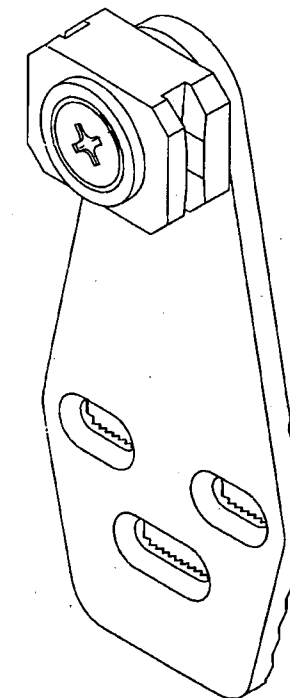




**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**

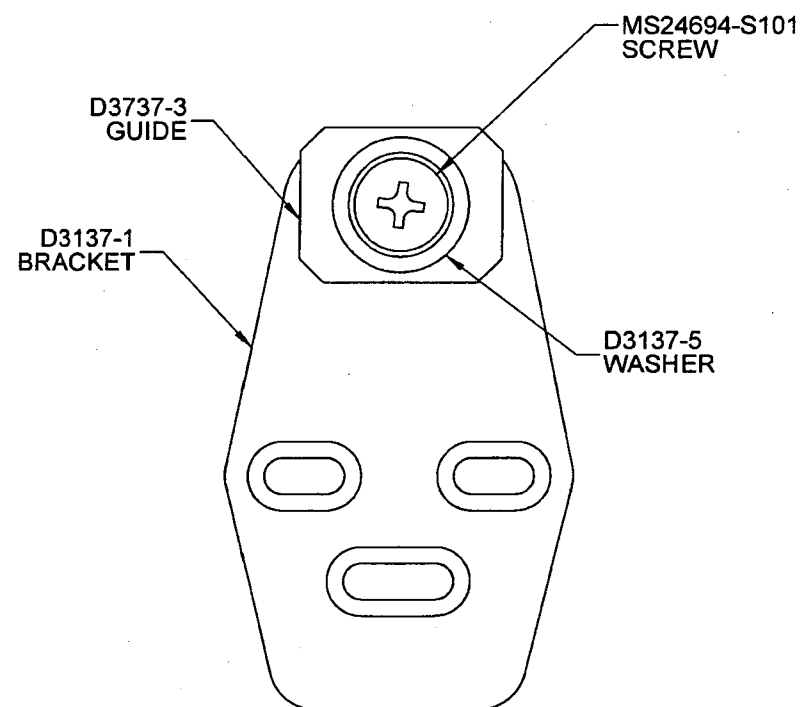


**D3137-045 BRACKET ASSEMBLY**

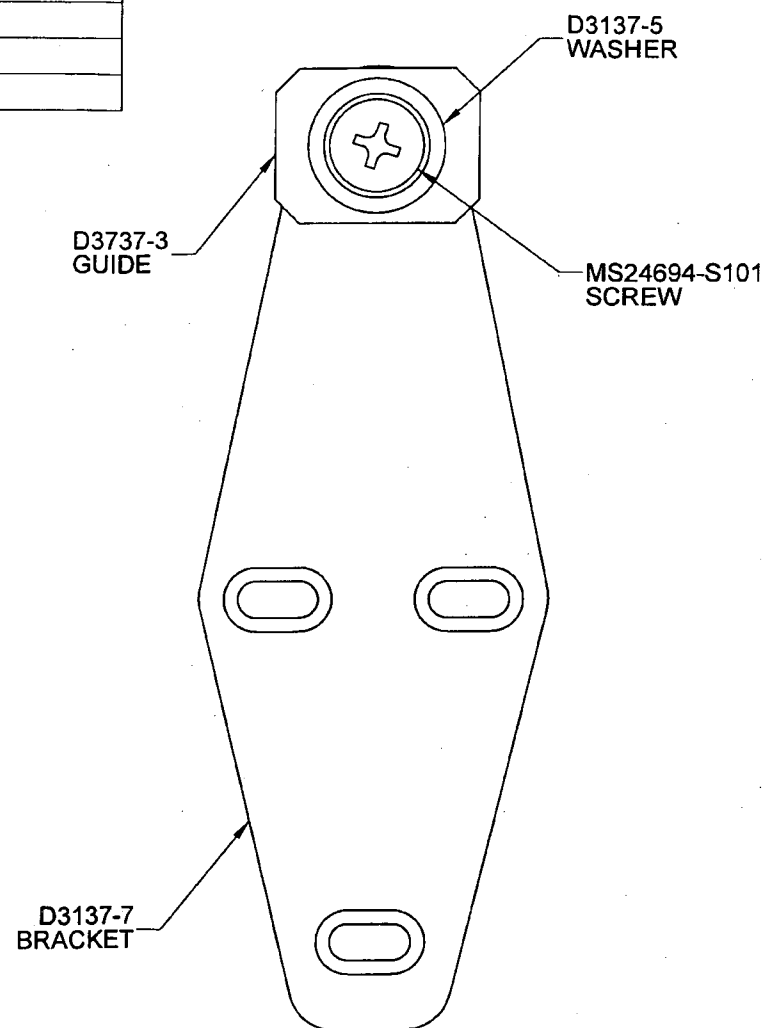
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NO. 42270

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.605, ZONE A.8 0.67 DIM WAS 0.79, ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 1 OF 5
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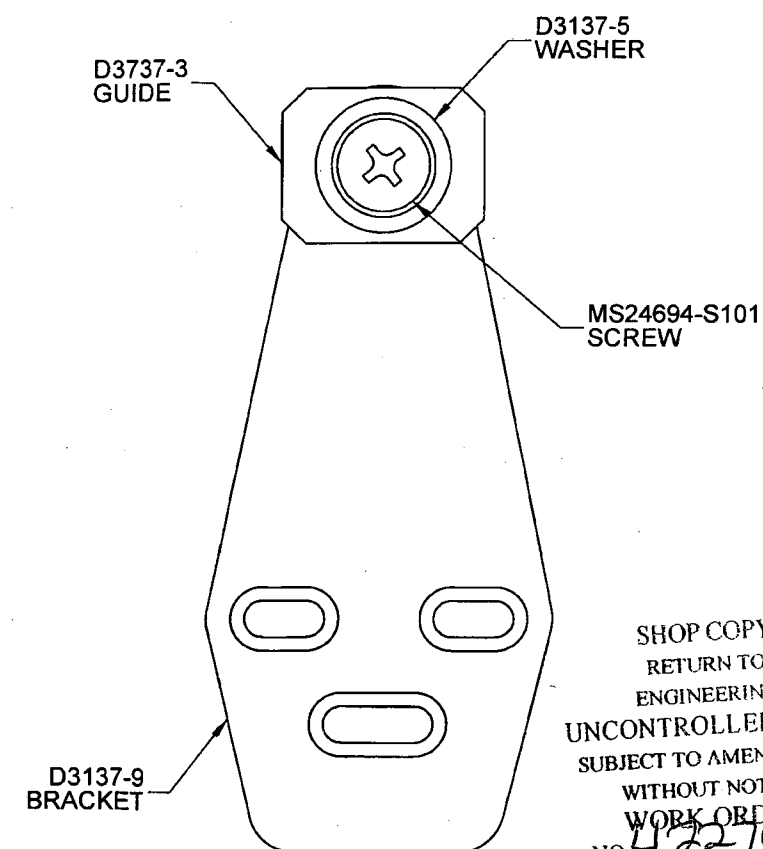
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

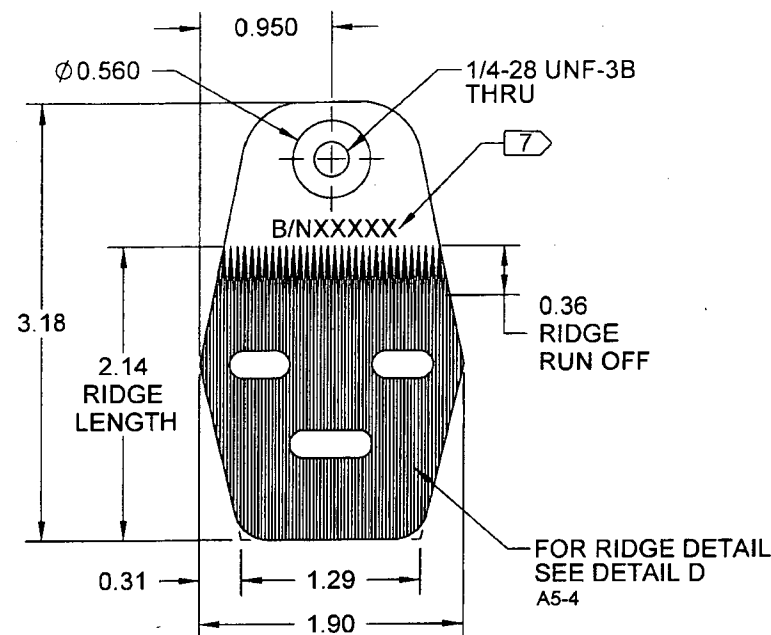
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041  
: 0.32 lbs -043  
: 0.27 lbs -045

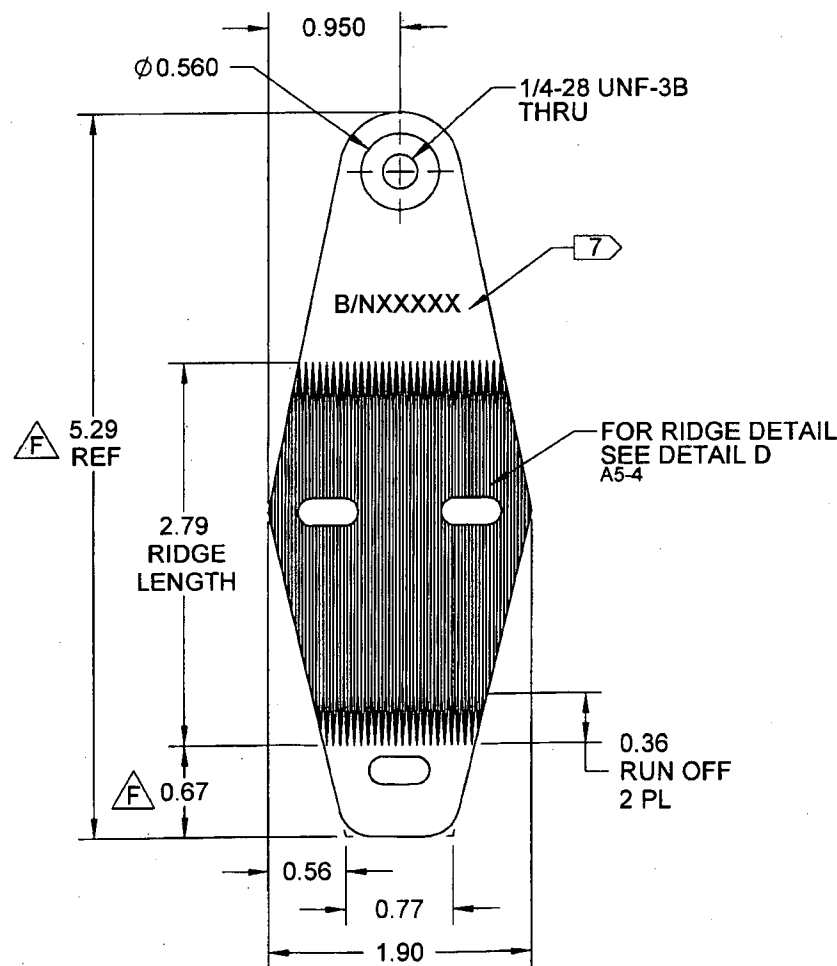
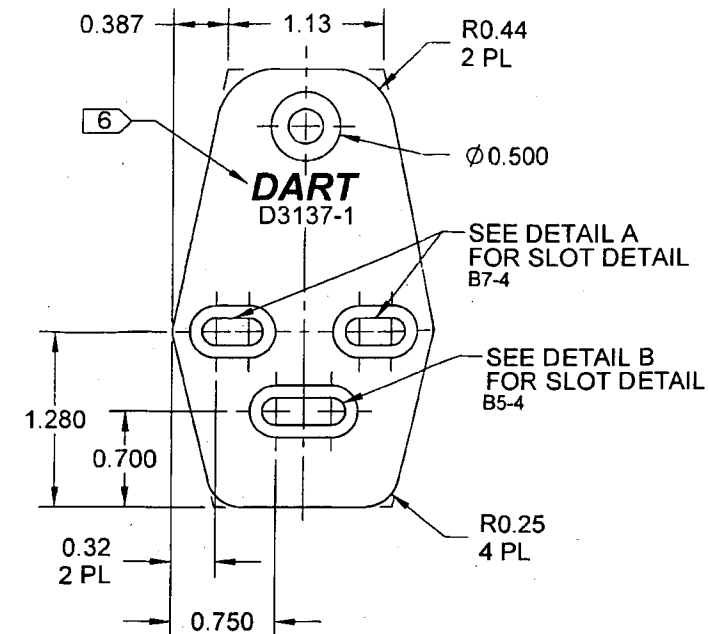
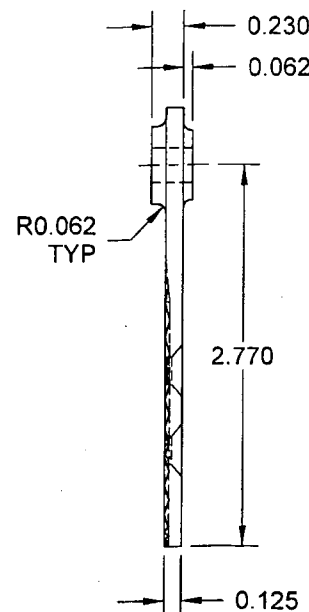
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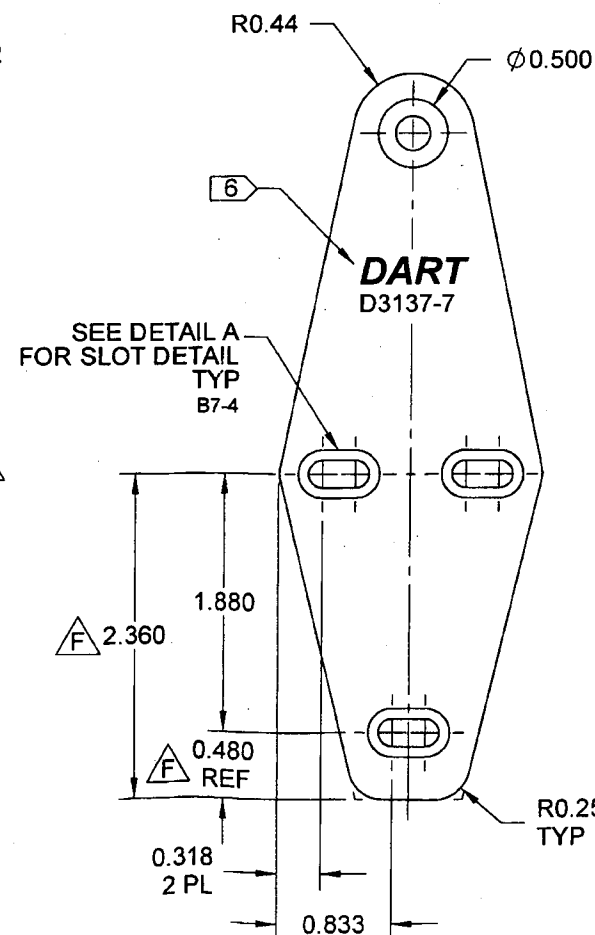
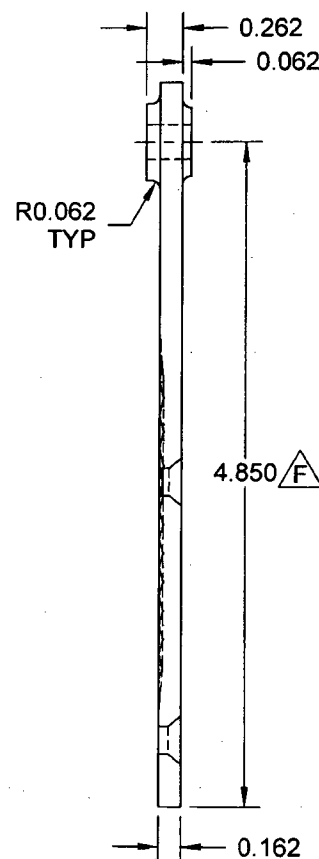
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**D3137-1 BRACKET**



**D3137-7 BRACKET**



**NOTES:**

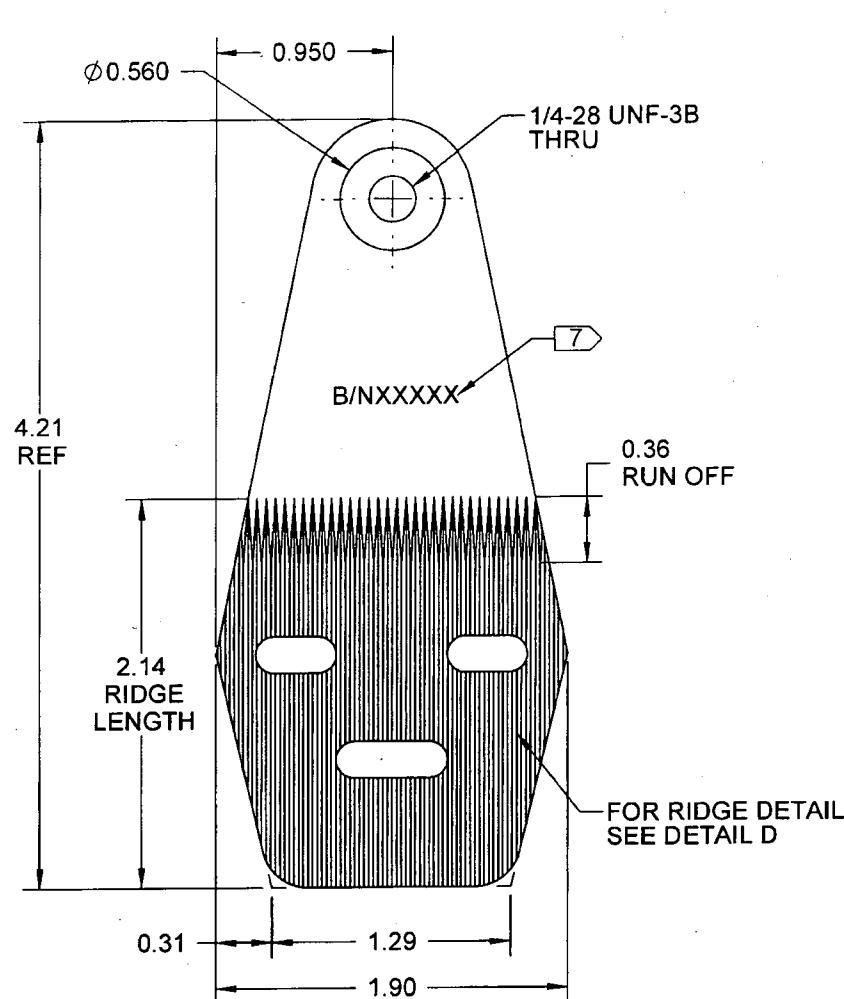
- 1) MATERIAL: -1 & -7  
17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-106

**RELEASED**  
08-06-26

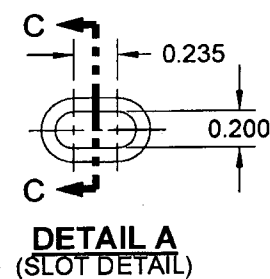
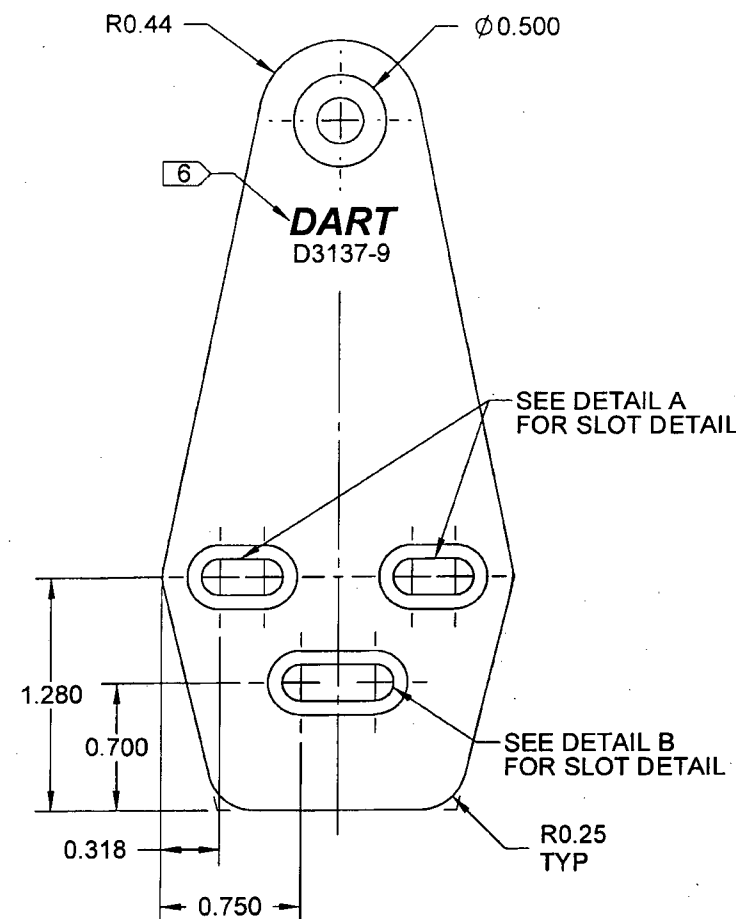
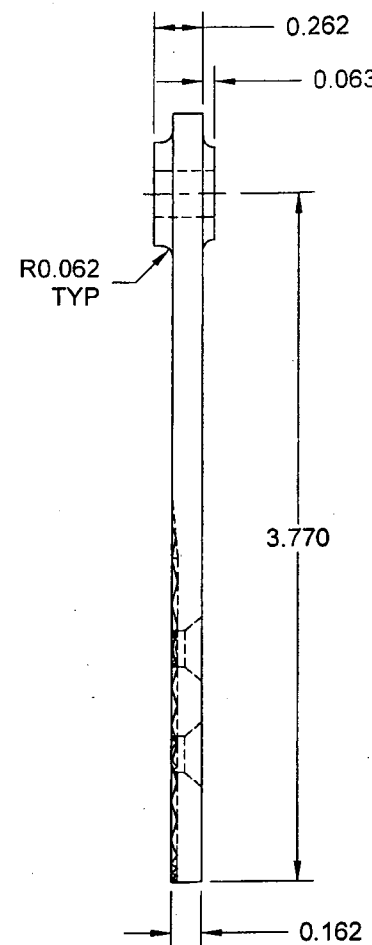
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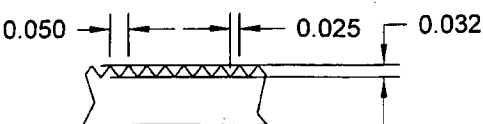
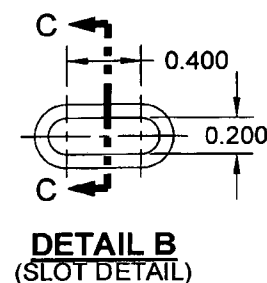




**D3137-9 BRACKET**



**SECTION C-C  
(SLOT DETAIL)**



**DETAIL D  
SCALE 2X  
(TYPICAL RIDGE DETAIL)**

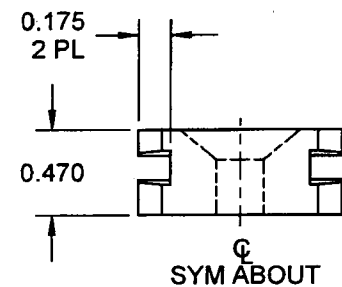
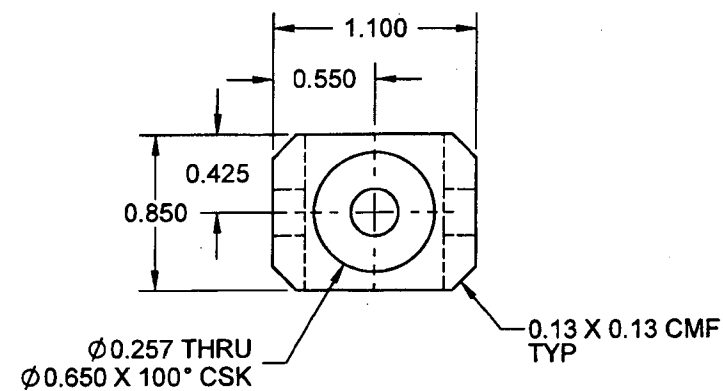
**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

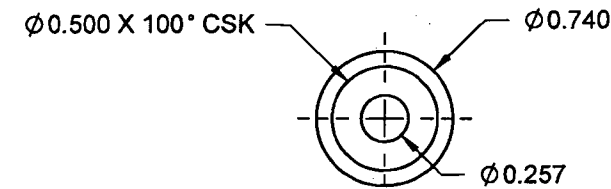
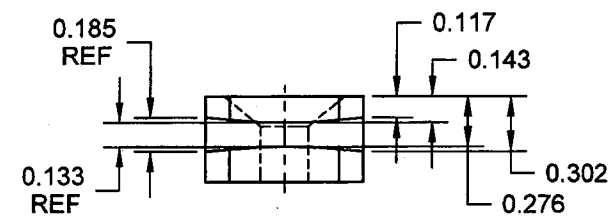
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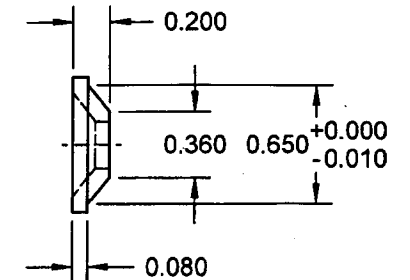
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**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

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